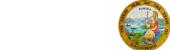
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 70.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-007674 Address: 333 Burma Road **Date Inspected:** 10-Jul-2009

City: Oakland, CA 94607

OSM Arrival Time: 1300 **Project Name:** SAS Superstructure **OSM Departure Time:** 2130 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Japan Steel Works **Location:** Muroran, Japan

CWI Name: CWI Present: Yes No Pin-Tang Hsu **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

Bridge No: 34-0006 **Component:** Tower, Jacking and Deviation Saddles

Summary of Items Observed:

On this date, 7/10/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2W1 - This QA Inspector observed the cast portion having had grid lines mapping out the casting in preparation for 100% Wet MT by the NDT personnel from the Foundry. Located in Fabrication Shop #4. W2W3 - Welder Y.Maeyama 94-5234, is FCAW welding lifting lugs to ends of saddle casting at locations previously buttered, the process was passed down to D.Kito of second shift, when, the monitoring of the weld parameters were then being performed by QC CWI Mr. Pin-Tang Hsu. The built up plate portion has returned to Fabrication shop #4.

TOWER SADDLES

- T1-2 Stiffeners are welded and contour grinding is in process to profile the welds.
- T1-3 Base plate, 9-4, was being welded by three individuals, M.Kubota 74-3666, R.Iizuka 06-2643 and M. Kashiwada 08-2008, joints in progress were 9Y-12L-2, 9Y-12L-2 and 9Y-12L-3 respectively. Procedure in use was SJ-3012-3, FCAW, 1.6mm TM55 weld wire, in Fabrication Shop #4. These functions were being monitored by QC CWI Mr. Chung Fu Kuan on a random basis. Second Shift personnel assuming the processes of these

WELDING INSPECTION REPORT

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joints were K.Kobayashi 08-5023 and Y.Watanabe 73-3873 welding joints 9Y-12L-2 and 9Y-12L-3 respectively. The duties of monitoring the parameters continued with CWI Mr. Pin-Tang Hsu.

EAST SADDLES and WEST JACKING SADDLE - On this day, QA Inspector Mike Brcic observed no work being performed in Foundry, apparent shut down for evening (time was 1620 local time, Japan).

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer